

Date: Monday, 02/03/2009 9:05:41 AM  
User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : STEP WELDMENT
<b>Job Number</b> : 46154	
<b>Estimate Number</b> : 10777	
<b>P.O. Number</b> :	<b>Part Number</b> : D3463042
<b>This Issue</b> : 02/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3463 REV.B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 46124	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 16/03/2009 <b>Qty:</b> 6 <b>Um:</b> EACH
<b>Checked &amp; Approved By</b> : <u>JLD 09.03.02</u>	
<b>Comment</b> : EST REV. A 05.11.18 new issue EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	238806	SS DOWEL PIN 1" LONG
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✓ **Comment:** Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	238-806	SS DOWEL PIN 1" LONG	M105037

2.0	D34533	Clevis
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✓ **Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3453-3	Clevis	B44791 x4 B46150 x2

3.0	D34637	Drag Arm
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✓ **Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-7	Drag Arm	B44795 x2 B 46271 x4 E2 9-3-17

4.0	D34631	Arm
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✓ **Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-1	Arm	B44481 x4 B46148 x2 E2 9-3-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 02/03/2009 9:05:42 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 46154

Part Number: D3463042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34633

Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D3463-3 Step B44482

FL 9-3-17

6.0

D34635

End Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch  
2 D3463-5 Step Flat Pattern B28513 x7 B46270 x5

FL 9-3-17

7.0

D34535

Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D3453-5 Plug B39463 x6

FL 9-3-17

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3463 using DT8875

FL 9-3-17 (46)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-03-17 (6)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/17 (46-042)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Mask areas indicated on dwg D3463 (holes, threads)

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: 2:00pm

09-03-17 (46)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 02/03/2009 9:05:42 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 46154

Part Number: D3463042

Job Number:



Seq. #:

Machine Or Operation:

Description :

OVEN TEMPERATURE: 400°F

FINISH TIME: 2:30pm

09-03-19

(X6)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



M110454



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3463 and QSI 005 4.4

09-03-20

(X6)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-23

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G-A

09/03/23

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/24

Job Completion



09-03-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

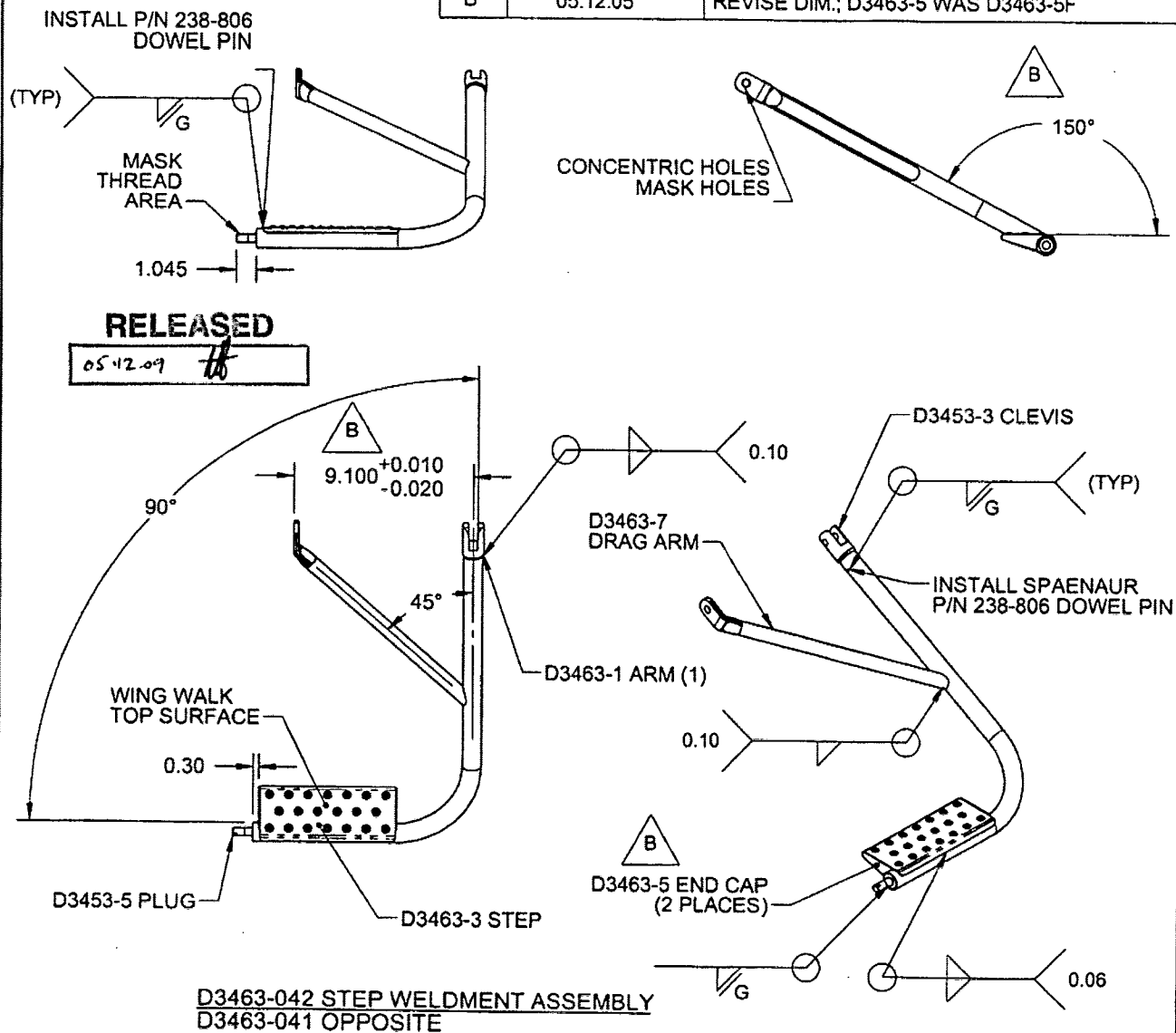
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. <b>D3463</b>	REV. B SHEET 1 OF 4
DATE <b>05.12.05</b>		TITLE <b>STEP WELDMENT</b>	SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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WORK ORDER

NO. *46154*

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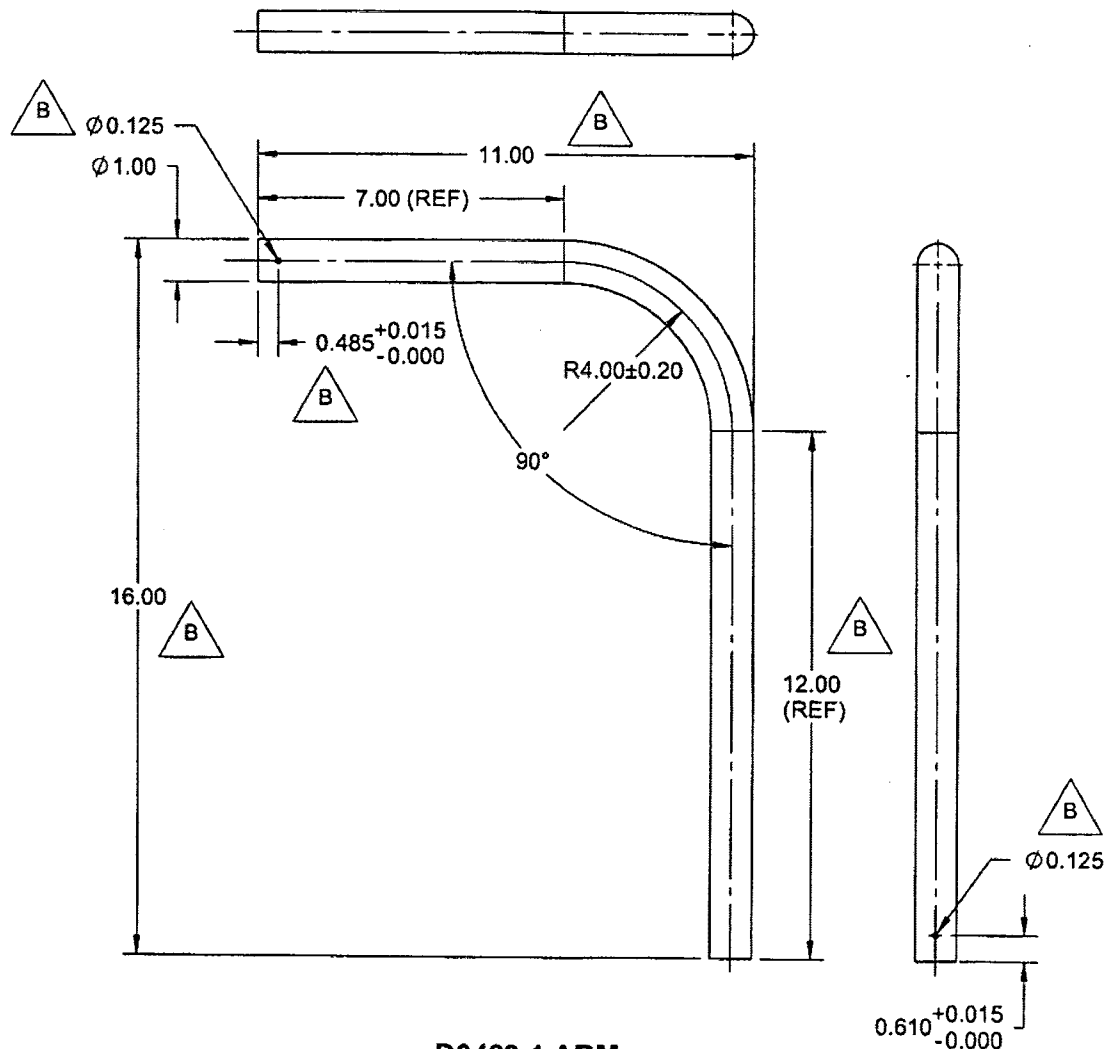
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED

05.12.05 *[Signature]*



**D3463-1 ARM**

**NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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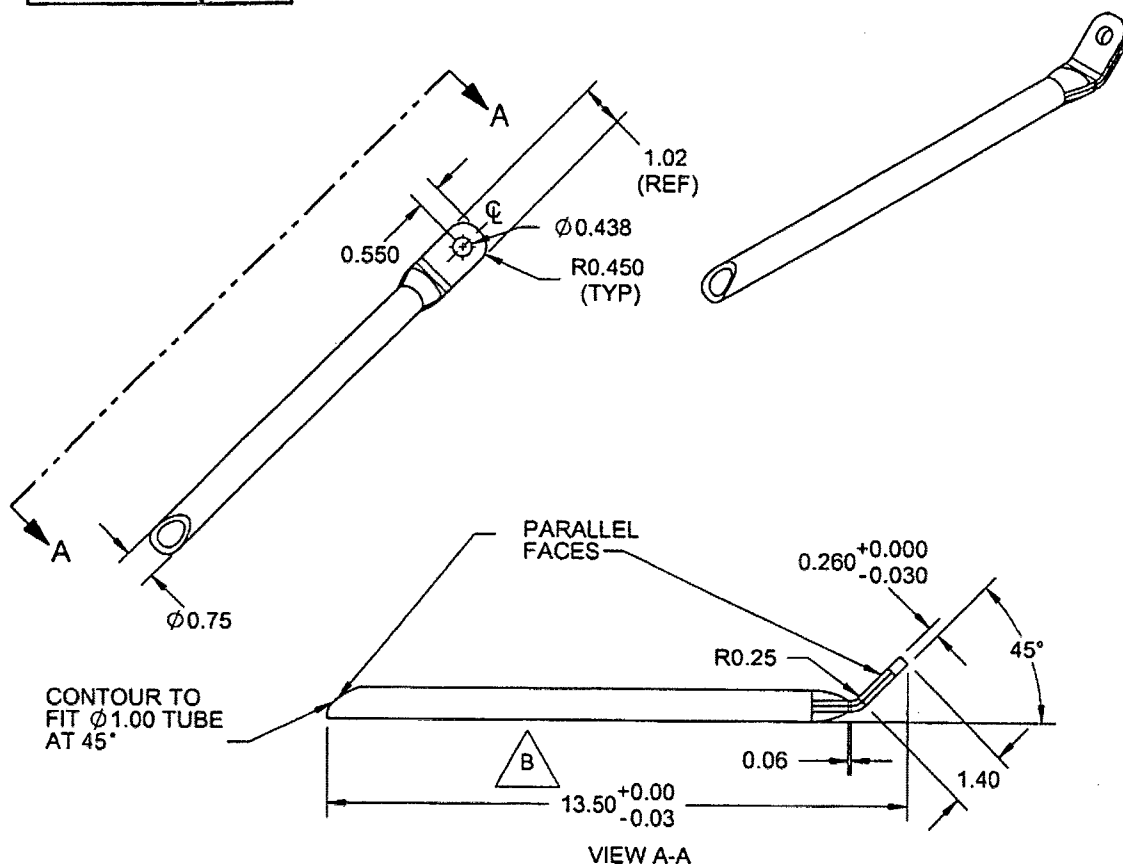




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DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED

05.12.05



**D3463-7 DRAG ARM**

**NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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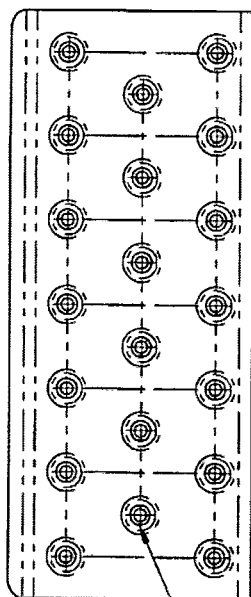
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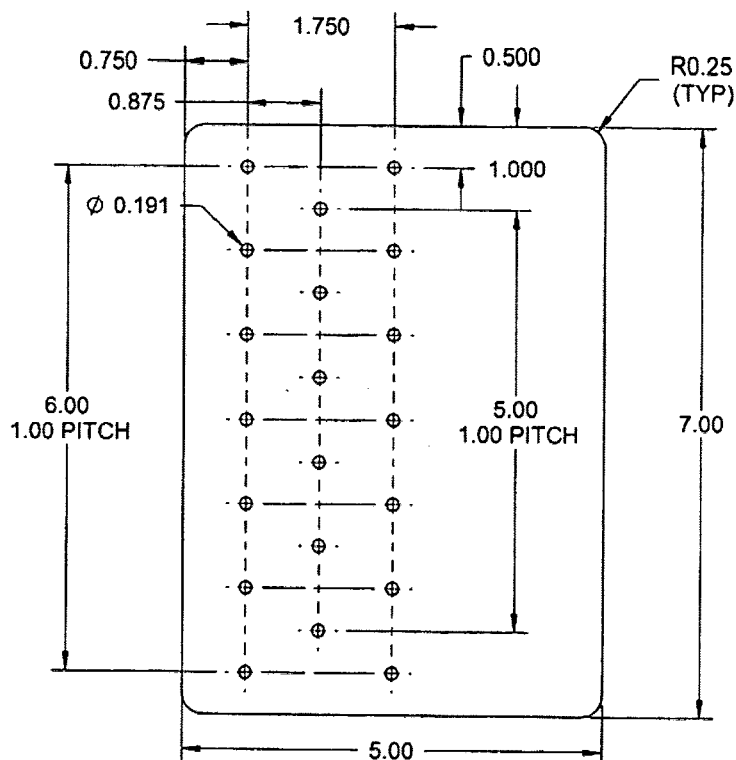
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DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:2

RELEASED

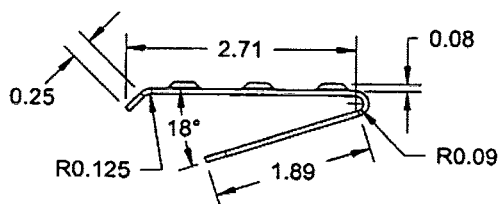
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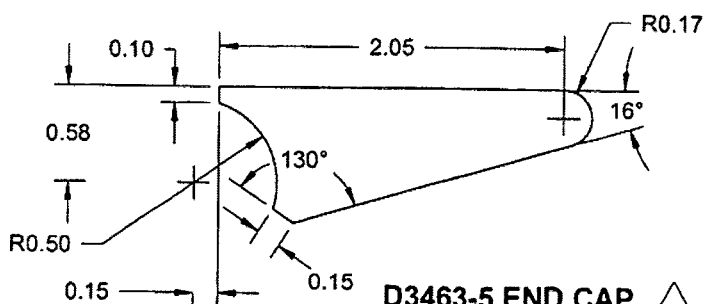
FORM USING  
D3463-3T1



**D3463-3F FLAT PATTERN**



**D3463-3 STEP**



**D3463-5 END CAP**  
SCALE 1:1



**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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